

Work Order ID 71314

Tuesday, June 28, 2011 9:58:49 AM



Page 1

Item ID: D3391-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Mid Tube Assembly

Start Date: 6/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: mf.

Date: 11-06-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



Skidtubes

Skidtubes

0.00

Memo

Skidtubes

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

5-Remove .030" from Fwd indexing Ridge as per Dwg D3391

6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

7-Deburr

8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

SCRAP

Pro →

DP 11-6-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-023 PAR #: N/A Fault Category: Landing Gear NCR: Yes No DQA: 11 Date: 11.07.04
11-695 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/07/05

NCR: <u>7314</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>#1140.15</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/6/29</u>	<u>#100.9</u>	<u>operator used wrong drill bit to open up wear plate holes. He put a 1/2" drill bit. Should of used 0.2921</u>	<u>[Signature]</u> <u>02/07/05</u>	<u>Scrap + Destroy</u> <u>mid tube qty +1</u> <u>No Refine</u>	<u>[Signature]</u> <u>11/06/29</u>	<u>S</u> <u>11/06/29</u>	<u>[Signature]</u> <u>02/07/05</u>	<u>S</u> <u>11/06/29</u>
		<u>P.C. operator error / Lack of Attention</u>						

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11-Open .375" holes to .438" ***do not open fwd saddle holes***

12-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

14- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

15- Locating from two fwd wearplate holes drilol remaining 6 wearplte holes in D3391-021 using DT8937

16- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

17- counterbore two aft wearplate holes in D3391-021 as per dwg

18- Open 12 wearplate holes in D3391-021 to 0.297" dia.

19-Deburr and blow out all chips from inside tube

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Tuesday, June 28, 2011 9:58:49 AM



Page 3

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
120 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00							
130 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tuesday, June 28, 2011 9:58:49 AM



Page 4

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Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: _____ batch#: _____								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
160 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Tuesday, June 28, 2011 9:58:49 AM



Page 5

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Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

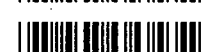
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC Quality Control	Memo	0.00							
180 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
185 	Pressure Wash per QSI005 4.3	0.00							
HandFinish Hand Finishing	Memo AND REALODINE AS PER PAR09-043	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Tuesday, June 28, 2011 9:58:49 AM



Page 6

Item ID: D3391-023

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Revision ID:

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Item Name: Mid Tube Assembly

Start Date: 6/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				_____	_____	_____	_____
200 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				_____	_____	_____	_____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[REDACTED]

Page 8

Accept

[illegible]

Setup Start

Abstract

Stop

Cust Item ID:[illegible][illegible]

Customer:

Reference:

Run Start

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

[illegible]

HandFinish

Memo

0.00

Hand Finishing

Install Inserts as per Dwg

0.00

[illegible]

QC

Memo

0.00

Quality Control

0.00

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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Tuesday, June 28, 2011 9:58:49 AM



Page 9

Item ID: D3391-023 Accept  Setup Start 
Revision ID: Stop 
Item Name: Mid Tube Assembly
Start Date: 6/28/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 7/28/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

MF 11-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, June 28, 2011 9:58:46 AM

Work Order ID: 71314



Parent Item: D3391-023



Parent Item Name: Mid Tube Assembly

Start Date: 6/28/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 05.10.20 New Issue KJ/EC
 IPP B 06.02.10 ECN773 dwg rev.D EC
 IPP C 07.03.20 rev F dwg EC
 IPP D 07.03.28 re-format EC
 IPP E 07.10.31 ecn 1053P EC
 IPP Rev:F ECN 1056 07-11-13 DD verified by: EC
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
 IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP
 Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-100 		Manufactured	No			100	Each	82.0000	1	1			
Skidtube Extrusion													
				<u>Location</u>				<u>Loc Qty</u>					
				HALL				82					
				37065				7					
				50251				75					
D3391-021 		Manufactured	No			100	Each	0.0000	1	1			
Fwd Tube Assembly													
D3389-1 		Manufactured	No			140	Each	0.0000	1	1			
Web													
D3681-1 		Manufactured	No			160	Each	24.0000	5	5			
Spacer													
				<u>Location</u>				<u>Loc Qty</u>					
				LG				24					
				68958				2					
				69893				22					

Wh
n/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

Tuesday, June 28, 2011 9:58:46 AM

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Parent Item: D3391-023



Parent Item Name: Mid Tube Assembly

Start Date: 6/28/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3591-1 Manufactured No

210

Each

27.0000

2

2



Bushing

Location

Loc Qty

Loc Code

ST068

27

57350

2

66147

25

ALS4-1032-130 Purchased No

230

Each

1,122.000

20

20



Insert

Location

Loc Qty

Loc Code

ST281

8

117331

8

ST282

1114

117717

1114

Tuesday, June 28, 2011 9:58:46 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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